

**Work Order ID 70332**

Friday, June 03, 2011 8:23:14 AM

*Ship today*

Page 1

Item ID: DSI 9500-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 6/3/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*MF*Date: *6-06-03*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9500

A

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP DSI9500-011  
CHG001*8/6/03*

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

*8/6/03 (2)*

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

*8/6/03**(2)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70332**

Friday, June 03, 2011 8:23:14 AM

Page 2

Item ID: DSI 9500-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 6/3/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 2.00

Customer:



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 		0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI9500-011 Location: _____ PPP rev: _____								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

6/6/3 @

11/6/3

MVG

11-06-09

# Picklist Print

Friday, June 03, 2011 8:23:10 AM

Page 1

Work Order ID: 70332

Parent Item: DSI 9500-011

Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 6/3/2011

Required Date: 6/3/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue DD 10.03.01 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2731-7 Mounting Lug		Manufactured	No			110	Each	71.0000	2	4			

Location	Loc Qty	Loc Code
ST470	71	
62929	27	
66427	32	
69177	12	

D2732-030 Rubber Cushion		Manufactured	No			110	Each	16.0000	8	16			
-----------------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST402	16	
69205	16	

D3394-043 Lug Assembly		Manufactured	No			110	Each	93.0000	2	4			
---------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST475	93	
62930	16	
62976	30	
66429	34	
69180	13	

62929

4/1/12

64283

62930

6/6/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 03, 2011 8:23:10 AM

Page 2

Work Order ID: 70332

Parent Item: DSI 9500-011

Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 6/3/2011

Required Date: 6/3/2011

Start Qty: 2.00

Required Qty: 2.00

D4064-041

Manufactured No

110

Each

23.0000

1

2



Mounting Lug

Location

Loc Qty

Loc Code

ST462

18

62977

18

ST464

5

58980

4

58985

1

52977

AN4C13A

Purchased

No

110

Each

93.0000

4

8



BOLT

Location

Loc Qty

Loc Code

ST357

90

114615

32

116199

8

117793

50

ST361

3

117688

3

116199

AN4C14A

Purchased

No

110

Each

62.0000

4

8



Bolt

Location

Loc Qty

Loc Code

ST337

40

117688

40

ST357

22

117366

22

117366

11/6/3 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 70332



Parent Item: DSI 9500-011



Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 6/3/2011

Required Date: 6/3/2011

Start Qty: 2.00

Required Qty: 2.00

AN4C15A Purchased No 110 Each 133.0000 4 8  
 Bolt

Location	Loc Qty	Loc Code
ST358	133	
115835	25	
115936	10	
117441	48	
117795	50	

AN960C416 NAS1149C0463 Purchased No 110 Each 0.0000 16 '32  
 washer

AN960C416L NAS1149C0463 Purchased No 110 Each 0.0000 8 16  
 WASHER

NAS1515H4L Purchased No 110 Each 236.0000 24 48  
 WASHER

Location	Loc Qty	Loc Code
FG	40	
103691	40	
ST277	196	
117363	196	

Friday, June 03, 2011 8:23:10 AM

Shop Packet Print

Page 3



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 03, 2011 8:23:10 AM

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Work Order ID: 70332



Parent Item: DSI 9500-011



Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 6/3/2011

Required Date: 6/3/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

110

Each

1,640.000

12

24



Nut



*Le 6/6/3 (2)*

Location

Loc Qty

Loc Code

FG	40	
104603	40	
ST300	512	
117423	512	
ST301	1088	
114784	48	
115936	40	
117601	500	
117793	500	

*1117423*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. F

REF FAA STC: SA00500SE

REF TCCA STC: SH98-14

REF EASA STC EASA.IM.R.S.01339

REFERENCE ONLY

## PURPOSE:

UNMODIFIED D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 005 (OR EARLIER) WILL NOT INSTALL AT THE 18.50" HEIGHT REQUIRED FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS.

## CHANGE:

D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 006 (OR LATER) CONTAIN NEW MOUNTING LUGS FOR COMPATIBILITY WITH APICAL FLOATS.

CONTRARY TO INSTALLATION INSTRUCTIONS IIN-D206-628, FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS, THE D206-628-013/-014 STEP INSTALLATIONS SHOULD BE INSTALLED AT A HEIGHT OF 17.25" PER FIGURE 1 OF THIS SERVICE INSTRUCTION.

WHEN INSTALLING THE MOUNTING LUGS, IT IS ACCEPTABLE TO USE LONGER/SHORTER AN4C BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960C416/416L WASHERS UNDER THE BOLT HEADS TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

PARTS LIST OF SECTION 5.2 (PG. 12) OF IIN-D206-628-013/-014 REV. F IS AMENDED AS FOLLOWS:

QTY -013	QTY -014	QTY -023	QTY -024	QTY -033	QTY -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INSTALLATION, LH
	X					D206-628-014	206 A/B FLOAT STEP INSTALLATION, RH

WAS:

2	2					D2731-3	MOUNTING LUG
2	2					D2731-7	MOUNTING LUG
2	2					D3394-041	MOUNTING LUG
2	2					D3394-043	MOUNTING LUG
16	16					AN960C416L	WASHER

IS:

4	4					D2731-7	MOUNTING LUG
4	4					D3394-043	MOUNTING LUG
1	1					D4064-041	MOUNTING LUG (NEW)
1	1					*D4064-1	LUG
2	2					*MS35489-93	GROMMET
16	16					AN960C416	WASHER

\* DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

A	NEW ISSUE	CP	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	GP	DART AEROSPACE USA, INC	
DRAWN	GP	PORT HADLOCK, WA	
CHECKED	3	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 1 OF 4
APPROVED	#	TITLE	SCALE
DE APPR.	#	MOUNTING LUG CHANGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
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THE DSI-9500-011 LUG UPGRADE KIT IS AVAILABLE TO UPDATE EXISTING D206-628-013/-014 STEPS TO CHANGE 006. THE UPGRADE KIT INCLUDES ADDITIONAL LUGS FOR STEPS INSTALLED WITH APICAL TRI-BAG FLOATS (AT 17.25" HEIGHT). EXISTING D206-628-013/-014 STEPS INSTALLED WITH OEM FLOATS (AT 15.00" HEIGHT) DO NOT REQUIRE THE KIT. THE UPGRADE KIT SHOULD BE INSTALLED PER THIS SERVICE INSTRUCTION AND IIN-D206-628 REV. F.

REFERENCE ONLY

QTY	Part Number	Description
X	DSI-9500-011	LUG UPGRADE KIT, 206 A/B FLOAT STEP
2	D2731-7	MOUNTING LUG (REPLACES D2731-3 MOUNTING LUG)
8	D2732-030	RUBBER CUSHION
2	D3394-043	MOUNTING LUG (REPLACES D3394-041 MOUNTING LUG)
1	D4064-041	MOUNTING LUG (REPLACES ONE D3394-043 FOR APICAL TRI-BAG FLOAT COMPATIBLE INSTALL)
4	AN4C13A	BOLT
4	AN4C14A	BOLT
4	AN4C15A	BOLT
16	AN960C416	WASHER
8	AN960C416L	WASHER
24	NAS1515H4L	WASHER
12	MS21043-4	NUT

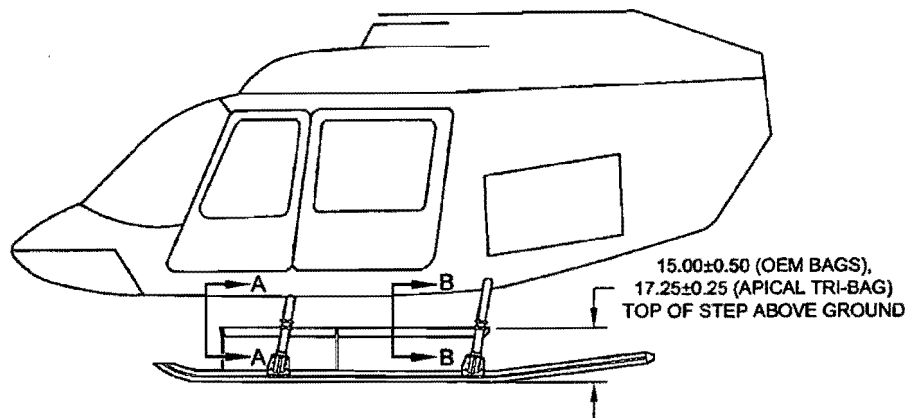
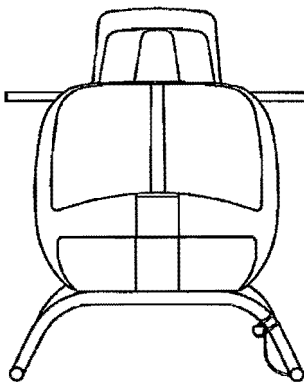


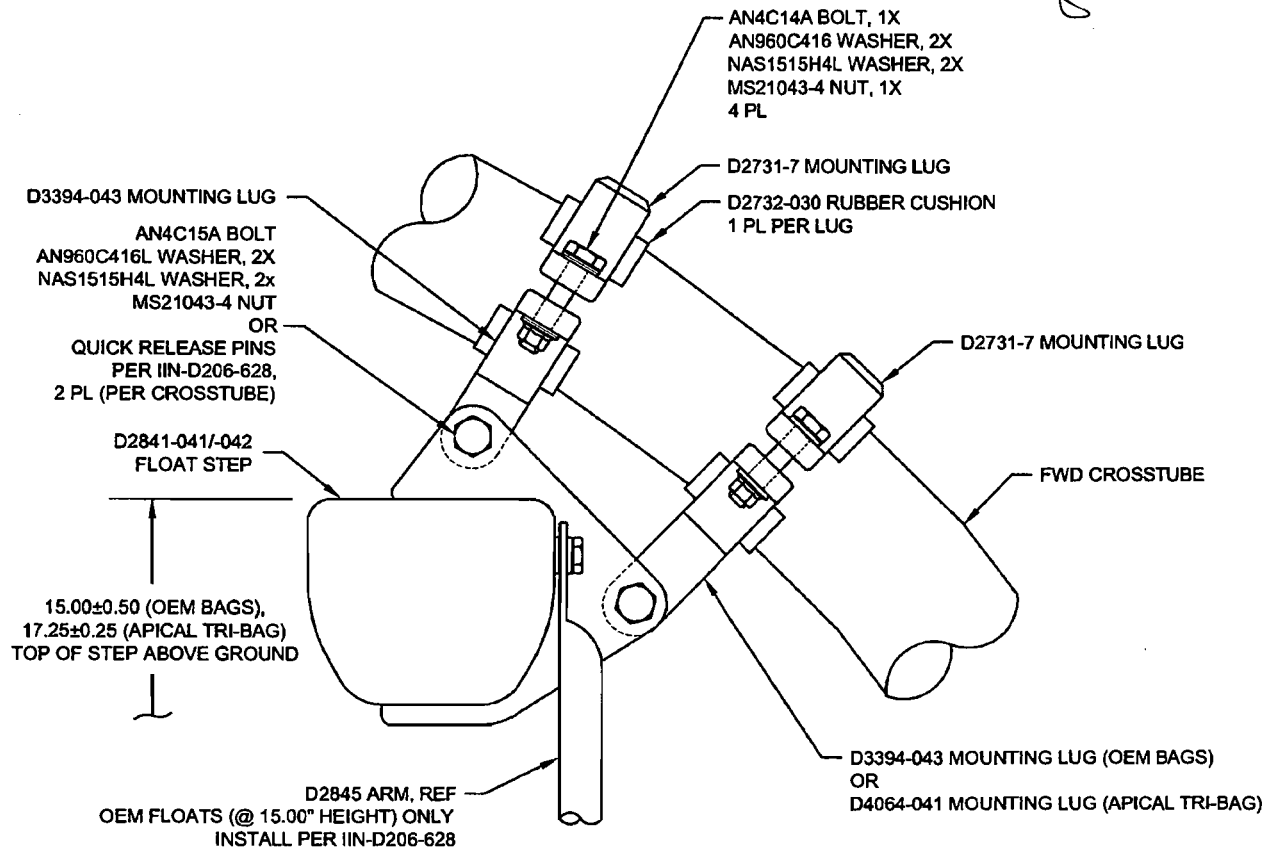
FIGURE 1

D206-628-013 (SHOWN) / -014 (OPPOSITE)  
206 A/B FLOAT STEP INSTALLATION

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG CHANGE	NTS
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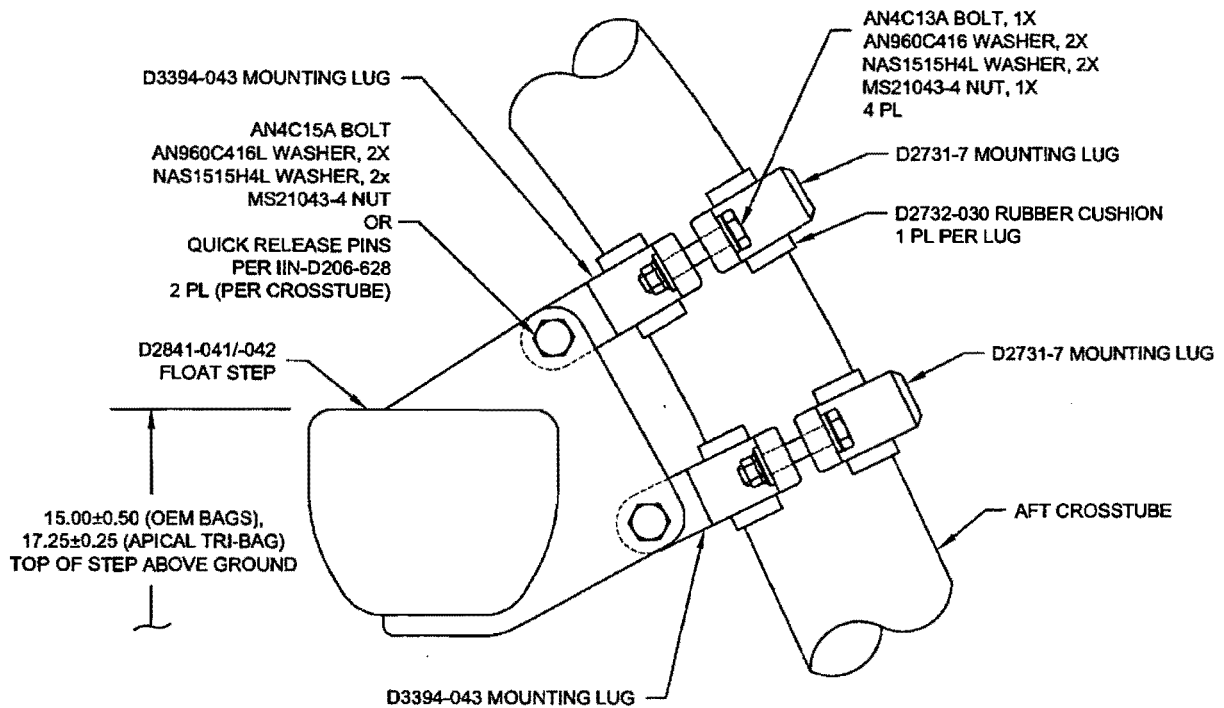
## SECTION A-A FWD CROSSTUBE CLAMPING DETAIL

DESIGN	<i>GP</i>	<b>DART AEROSPACE USA, INC</b>	
DRAWN	<i>GP</i>	PORT HADLOCK, WA	
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 3 OF 4
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>GP</i>	MOUNTING LUG CHANGE	NTS
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REFERENCE ONLY



**SECTION B-B**  
AFT CROSSTUBE CLAMPING DETAIL

DESIGN	99	<b>DART AEROSPACE USA, INC</b>	
DRAWN	99	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG CHANGE	NTS
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